



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T101576-13
Job Sheet 185144



Part No: RB T101576-13

Job Qty: 4 ea

Part Name: Base



Part Weight: 0 lbs

DAS

Status: New

Priority: Medium

Job Created: 10/23/18

21

Job Tracking No:

Due Date: 11/30/18

9-89

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101576 Rev.5 IPP Rev. A 18.10.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	4 pcs		11/30/18	0.00	0.00	Purchasing		DEC 10 2018
110	Packaging	4 pcs		11/30/18	0.00	0.00	Packaging2		DEC 10 2018
120	QC	4 pcs		11/30/18	0.00	0.00	QC6		38
130	Packaging	4 pcs		11/30/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	4 Ea		11/30/18	0.00	0.00	QC21		21 DEC 11 2018

Part Op 100 - Issue P/O: 0011487 MANUFACTURE RB T101576-13 AS PER DWG Supplier: METEC Certificate of conformity
Descriptions: is required

act 26. 2018 x4 Rth PJ mach.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T101576-13P	Base	4 Ea (1 ea)	100-Purchasing	5136227

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T101576-13P	4	0	0

Part Specifications

Specifications could not be found.

Plex 10/23/18 10:12 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S136228



Part: RB T101576-13

Job No: 185144

Serial No/Batch: S136228

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 12/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

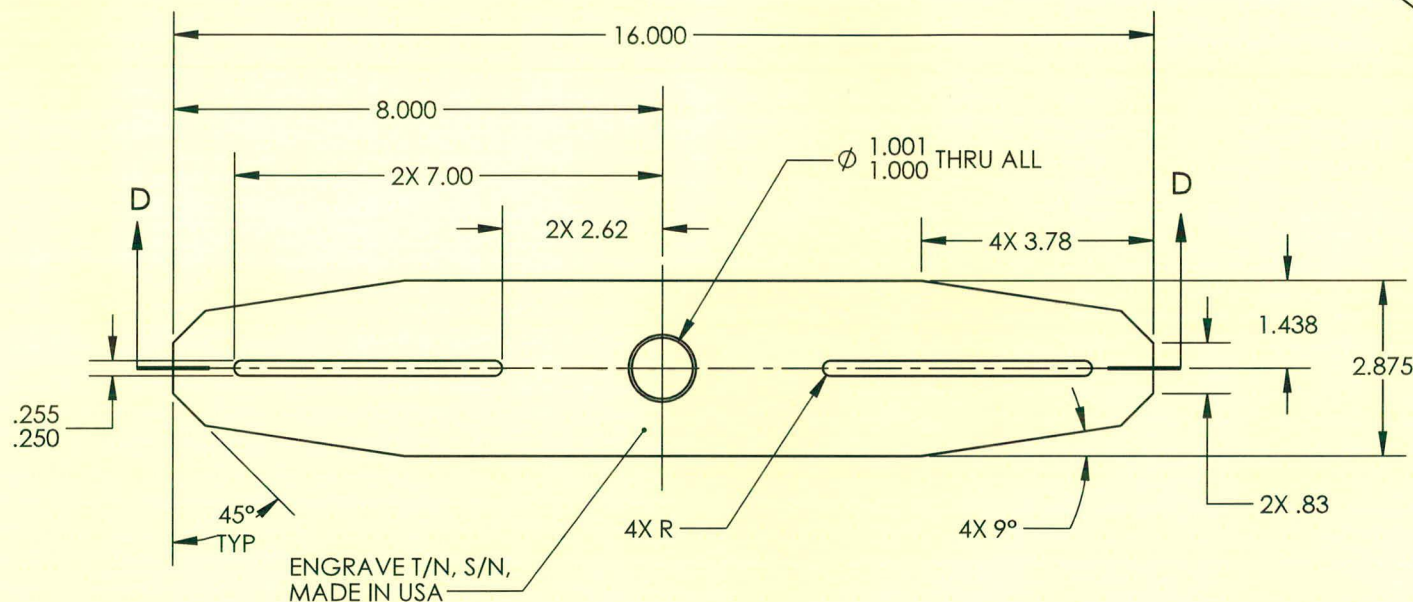
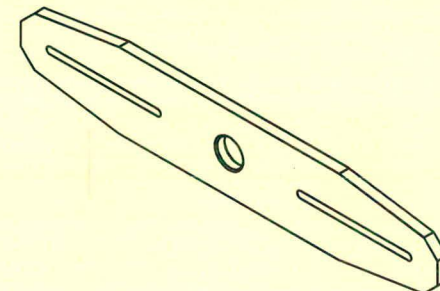
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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				Lead hand / Supervisor Approval Verification																																																																	
				QC / QA Coordinator Approval																																																																	
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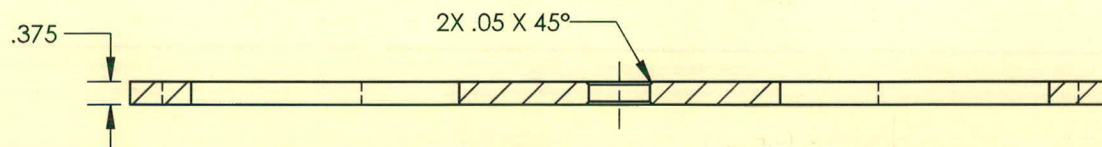
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		-13 CH'D MATERIAL WAS 2024 IS 6061.	6/25/2013	BIM	EB
5	15-0067	-13 ADDED ENGRAVE T/N, S/N, MADE IN USA NOTE.	4/15/2015	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 185144 ULS
18-10-23



SECTION D-D

(-13)

BASE



TITLE			REV	
BALANCE SET - MAIN & TAIL ROTOR			5	
DWG NO.			RB T101576-13	
MAT'L 6061			DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			APPROVED <i>D Weil</i>	
.XXX ± .010 FRACTIONS ± 1/8			HEAT TREAT	
.XX ± .03 ANGLES ± 5°			FINISH CLEAR ANODIZE	
.X ± .1			SPEC MIL-A-8625F, TYPE II, CLASS I	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R			USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			BELL 206 & 206L	
SCALE 1:3		DATE 1/9/2012		SHEET 7 OF 11



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041487**

Supplier: PJM001-VC
P.J. Machinage
1381 Rte Cite-Des-Jeunes
St-Lazare
QC
J7T 2B8
Phone: 450-455-0705

PO No: PO041487
PO Date: 10/26/18
Due Date: 11/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185144	RB T101576- 13P			Base REV 5 4 X	Firmed	-	11/29/18 12/10/2018	4 Ea	0 Ea	4 Ea	\$170.75/Ea	\$683.00
Grand Total:													\$683.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/26/18 2:20 PM dart.Lussier.Patrick

Shipping Order

26/10/2018

P.J. Machinage (9052 9470 Qc Inc).
1381, Rte Cité-Des-Jeunes,
St-Lazare, Qc
J7T 2B8

Tel. : 450 455-0705

Order : 7209
Reference : PO041487-S/O : 7209
Bid : 15332
Ship : Pick Up

Customer : 628

Ship To

Dart Aerospace Ltd.
Accounts payable
1270 Aberdeen St
Hawkesbury, Ontario
K6A 1K7

Same

Fax: 1 613 632-5246

Item No.	Description	Qty	Qty. Delivere	B/O Qty
001	RB T101576-13 Rev. 5 Balance Set-Main & Tail Rotor	4	4	0

DAS
38
9-89

P.J. Machinage retains ownership of all goods sold and other work-product delivered to or performed for its customer until full and complete payment of the underlying invoice, even in circumstances where the part to be machined or materials were provided by the customer. In cases where the part of materials belonged to the customer before it is remitted to P.J. Machinage for the prupose of performing work thereon, its delivery to P.J. Machinage shall entail a transfer of the underlying rights of ownership of the customer over said part or materials.

Shipping : Voire Camier
Package No : _____
Merchandise Received: 7/12/2018

Ref. : _____

PJ Machinage

Certificate of conformance

Sold to:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON, K6A 1K7

Supplier address:

PJ Machinage
1381 Route Cité-Des-Jeunes
St-Lazare, Qc, J7T 2B8

Purchase Order: PO041487

This is to certify that the below names items were inspected and/or tested to your drawings, specifications and purchase order. Objective evidence are shipped with the products and are on file to support the verifications and/or tests and can be made available on request, unless otherwise noted.

<u>Part Number</u>	<u>Quantity</u>	<u>Description</u>
RB T101576-13 Rev. 5	4	<u>Balance Set-Main & Tail Rotor</u>

 , December 05 , 2018



Service Center Metals

5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS



OUR ORDER NUMBER	ITEM
950616	4

BILL TO

Thyssenkrupp Materials NA

SHIP TO

ThyssenKrupp Materials NA-St Laurent, QC

Quantity Certified 1,016 lbs 64pcs

MANIFEST NUMBER

367294

CUSTOMER PO

5400400635

CUSTOMER PART NUMBER

ALREC00153

DIE NUMBER

RB0087

ALLOY / TEMPER

6061-T6511

DESCRIPTION

SCRB .375 x 3.000

DATE OF SHIPMENT

5/16/2018

SALESPERSON

D. Schroeder (Canada)

CERTIFICATION

ASTM-B221-14 StencilCont

SPECIFICATION

RoHS 2011/65/EU Compliant

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. Items produced and certified as 6061-T6511 also meet the requirements of 6061-T6.

All aluminum products supplied by Service Center Metals, LLC contain no functional mercury. Neither mercury nor its compounds are used in the manufacture of aluminum products at our facility. Furthermore, aluminum products supplied by Service Center Metals have not, to the best of our knowledge, contacted any source of mercury.

SCM is ISO 9001-2015 certified

This product is RoHS-2, REACH, and DFARS compliant.

Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
			min	max	min	max	min	max
6	201807550	4/25/18	43.70	45.10	40.50	42.20	18.30	20.10

Chemical Composition for Aluminum Alloy 6061

Cast #	Lot No.	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	AL	Others		Melt Source
												Each	Total	
002E180408B	201807550	6061	0.62	0.28	0.20	0.05	0.85	0.08	0.08	0.03	97.82	0.05	0.15	United States of America
002J180408B	201807550	6061	0.62	0.28	0.20	0.05	0.85	0.08	0.08	0.03	97.82	0.05	0.15	United States of America

SCM products are melted and extruded in the USA

Calvin J. Wiggins, Director of Quality & Technical Services

Print Date: 5/16/2018

Rev 3/14/2018

From: TK Materials CA, Ltd.
Cust. 9052-9470 QUEBEC INC
CStar
Wgt.: 15 LB

Del.: 2406330522
CstOr 135509
Date 10/29/2018

Handwritten signature

7209



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

7209
Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

014892- 1

Livré à / Ship to

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes
St-Lazare, QC, J7T2B8
CANADA

Tel.: 450-455-0705 Fax.: 450-455-1167

Client / Customer:

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes
St-Lazare, QC, J7T2B8
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
05-Dec-2018		Ross Montieth			135663			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	LOT 4 PARTS Rev.	LOT 4 PARTS 01 -ANO-CLEAR (ANODIZE CLEAR)	ANODIZE MIN-CHG	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

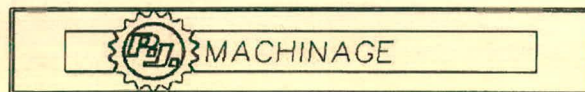
Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

CLIENT: 628
JOB No.: 7209
PLAN No.:
P.O.: 1004/1087
QUANTITÉ: 4



DATE: 28/11/2019
 FORMAT No.: 001
 PAGE No.: _____

CONTRÔLE DE QUALITÉ

NOM DE LA PIÈCE: 125 T101576-13 REV. 5 MATÉRIEL: Alum 6061-T6511
BACARD SET-MAIN & TAIL 10/15/76

DIMENSIONS DE DESSIN ET TOLERANCE

[illegible]

OBSERVATION:

SIGNATURE RESPONSABLE:

Richard

